### Work Order ID 53403

Н

November 03, 2009 3:54:50 PM



Page 1

Item ID:

D2221

Accept

Setup Start

Stop

Stop



Revision ID:

Item Name: 350 Basket Base

**Required Date: 11/11/2009** 

Start Date:

11/4/2009

Start Oty: 1.00

Req'd Otv: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

**Process Plan:** OC:

**Revision Nhr** 

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Otv

Sequence ID/ Work Center ID Operation Description Set Up/ **Run Hours**  Draw Number

Plan Draw Rev. Code Accept Oty

Reject Reject Number

Insp. Stamp

**Draw Nbr** D2221

Rev H

100

Large Fab Large Fab

Large Fab

Memo

0.00

0.00

a

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 \* DS1 9473

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per

dwg D2221

3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: 4 1092 3

110

QC9- Inspect visual per OSI004- Fusion Welds

0.00

**Ouality Control** 

Memo

0.00

M09/11/10 (1

Dart Aerospa	ce	Ltd
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W/O:			W	ORK ORDER CHANGI	ES	,				
DATE	STEP	PRO	PROCEDURE CHANGE By						Approval Chief Eng / Prod Mgr	Approval QC Inspector
					·					
Part No		PAR #:								
	R	esolution:	_ Dispositi	on:	_ QA: N	I/C Clos	sed:		Date: _	
NCR:		W	ORK ORE	DER NON-CONFORMA	NCE (	NCR)				
DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
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#### Work Order ID 53403

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Page 2

Item ID:

D2221

Accept

Setup Start

Item Name:

Н **Revision ID:** 

350 Basket Base

Start Date:

11/4/2009

Start Otv: 1.00 Rea'd Otv: 1.00

Cust Item ID:

**Customer:** 

**Required Date: 11/11/2009** Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

OC:

Date:

SPC (Y/N):

Date:

Stop

Stop

Sequence ID/ Work Center ID

OC

Quality Control

Operation Description

QC6-Inspect dimensions to drawing

Set Up/ Run Hours 0.00

Number

Draw Rev.

Plan

Code

Accept Oty

Reject Reject Otv Number

Insp. Stamp /

Memo

0.00

Draw

130



Powder Coating

White Gloss(Ref:4.3.5.2) per OSI005 4.3-Steel

M112.148

0.00

H 09/11/11

1- Plug holes prior to

IST COAT: START TIME: 8:30 AM

Memo

OVEN TEMPERATURE:

START TIME: 410 AM

OVEN TEMPERATURE: 4009=

FINISH TIME: 4:40Am

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	·	W	ORK ORDER CHAN	GES	-				
STEP	PRO	OCEDURE CHA	ANGE	į	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	PAR #:	Fault Cate	egory:	NC	R: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	
		WORK ORD	ER NON-CONFORM	<b>IANCE</b>	(NCR	)			
STEP	Description of NC					Verific	ation	Approval	Approval
J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	ו	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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	): 	STEP PRODUCTION OF THE PRODUCT	PAR #: Fault Cate  Resolution: Disposition  WORK ORD  STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE  PAR #: Fault Category:  Resolution: Disposition:  WORK ORDER NON-CONFORM  STEP Description of NC Section A Corrective Action Security Section A Corrective Action Description	STEP PROCEDURE CHANGE  PAR #: Fault Category: NCF Resolution: Disposition: QA:  WORK ORDER NON-CONFORMANCE  STEP Description of NC Section A   Corrective Action Section B   Initial Action Description	STEP PROCEDURE CHANGE By  PAR #: Fault Category: NCR: Yes  Resolution: Disposition: QA: N/C Clo  WORK ORDER NON-CONFORMANCE (NCR  STEP Description of NC Section A	STEP PROCEDURE CHANGE By Date  PAR #: Fault Category: NCR: Yes No DQA  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty  PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Section B Section C Section C	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr  DEPAR #:Fault Category:NCR: Yes No DQA:Date:

### Work Order ID 53403

November 03, 2009 3:54:50 PM

**Required Date: 11/11/2009** 



Page 3

Item ID:

D2221

Н **Revision ID:** 

Item Name:

350 Basket Base

Start Date:

11/4/2009

QC:

Start Oty: 1.00 Req'd Oty: 1.00



Accept

Run

Setup Start



**Cust Item ID:** 

**Customer:** 

Draw

Reference:

Approvals:

Process Plan:

Date:

Tooling: SPC (Y/N):

0.00

0.00

Date:

Date:

Start

Stop



Stop

Sequence ID/

Work Center ID

140

Quality Control

Operation Description

OC3- Inspect Part Finish

Memo

Date: \_\_\_\_\_

Set Up/ **Run Hours** 

Number

Rev.

Draw

Plan Code

Accept Qty

Reject Reject Number

Insp. Stamp

PMD 5340)

Qty

150

OC Quality Control QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Mr 0911/12/2

W/O:			WO	RK ORDER CHAN	ICES		<u> </u>	· .		
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Part No	•	PAR #:	Fault Categ	ory:	NC	R: Yes	No <b>DQ</b>	A:	Date:	<u> </u>
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DATE	STEP	Description of NC			ection B	Ci 0	Verific	cation	Approval	Approval
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#### **Picklist Print** November 03, 2009 3:54:49 PM Work Order ID: 53403 Parent Item: D2221RevH Parent Item Name: 350 Basket Base **Required Date: 11/11/2009** Start Date: 11/4/2009 Start Otv: 1.00 Required Otv: 1.00 Comments: Component Item ID/ Replacement Mfg/ Bin Primary Last Route Unit of Qty on Remaining Qty Date Item Name Item ID Item Location Location Sea ID Measure Hand Otv To Pick Issued Issued Purch D2221-1RevH Manufactured No 100 Each 23.0000 1.0000 SAD 09-11-10 Rib Warehouse Loc Otv Loc Code Location Main Warehouse ST 1 48101 Main Warehouse WA 22 51872 10 53213 12 D2221-5RevH No 100 Each 6.0000 2.0000 Manufactured Warehouse Loc Oty Loc Code Location Main Warehouse ST 6 53131 D2221-7RevH Manufactured No 100 Each 3.0000 1.0000 09-11-10 Rib

Warehouse Loc Qty Loc Code Location Main Warehouse WA 3 51251 3

Status

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W/O:			WORK ORDER CHANGES												
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		esolution:							Date:						
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November 03, 2009 3:54:49 PM

Work Order ID: 53403

Parent Item:

D2221RevH

Parent Item Name:

350 Basket Base

**Comments:** 



No

**Start Date:** 11/4/2009

**Required Date:** 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
D2232-3RevC		Manufactured	No			100	Each	7.0000	2.0000			



Basket Hinge

09-11-10

Warehouse	<u>Lo</u>	c Oty	Loc Code			4 .
<b>Location</b>		R 633			_ 2,	Modula
Main Warehouse		B533	44 -		<u> </u>	2709/11/06
ST		7				• •
50024		2				
51870		5				
	100	Each	16.0000	2.0000		
					C10	00 11 113

Manufactured

Basket Rib

D2235-1RevB1

Warehouse	Loc Oty	Loc Code
<b>Location</b>		
Main Warehouse		
ST	3	
51438	3	
Main Warehouse		
WA	13	

3

10

2x Sy 09/811/06

50565

51871

W/O:			WO	RK ORDER CHANGI	ES	····	H		
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	<b>:</b>	PAR #:	Fault Cate	Jory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
·	Res	solution:						Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Date	Sect	ion C	Chief Eng	QC Inspector
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November 03, 2009 3:54:49 PM

Work Order ID: 53403

Parent Item:

D2221RevH

Parent Item Name:

350 Basket Base

Comments:



**Start Date:** 11/4/2009

**Required Date:** 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Item Name Item	ID i	Mfg/ Purch	Item Lo	imary ecation	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1	_	Manufactured	No			100	Each	56.0000	2.0000			



Mounting Bracket

Warehouse	Loc Oty	Loc Code	
<b>Location</b>			
Main Warehouse			
ST	12		
46086	2		
48428	1		
51120	9		
Main Warehouse			
WA	44		
50872	1		0.1
51745	43		2x Sy 09/11/06
	100 Each	14.0000 2.0000	20,01111100
			SAN 09-11-10



Manufactured

No

Shim

Warehouse	Loc Qty	Loc Code		
<b>Location</b>				
Main Warehouse				
ST	1			
46767	1			
Main Warehouse				
WA	13			0.1 1 1
50951	13		- 2 x	JY 09/11/06

W/O:	•		\MC	RK ORDER CHANG	EC	,			
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
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·									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositio	1:	_ QA: N/C C	losed:		Date: _	
NCR:	. 1617 (64		WORK ORDI	ER NON-CONFORMA	ANCE (NC	R)			<u>_</u>
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Corrective Action Description	Sign	&   Sect	cation ion C	Approval Chief Eng	Approval QC inspector
			Chief Eng	Chief Eng	Date				
			5*						

November 03, 2009 3:54:49 PM

Work Order ID: 53403

Parent Item:

D2221RevH

Parent Item Name: 350 Basket Base

Comments:



Start Date: 11/4/2009

**Required Date: 11/11/2009** 

Start Qty: 1.00

Required Qty: 1.00

09-11-10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3825-041RevA		Manufactured	No			100	Each	4.0000	2.0000			
										AD	Od-11-10	

Rib Assembly (Basket End)

Warehouse	Loc	<u>Oty</u>	Loc Code		
<b>Location</b>		0	م		
Main Warehouse		8533	81 × 7	L.	
ST		4			
51869		4			
	100	Eoch	4.0000	2 0000	

D3826-041RevB

Manufactured

No

Rib / Gusset Assembly

Warehouse Location Main Warehouse	<u>Lo</u>	c Oty	<u>Loc Code</u> 53216		− 2x	SY	09/11/06
ST		4				<del></del>	
51340		4				_	
	100	Each	3.0000	1.0000	QAI)	MQ1/-	ſĎ

D3827-041RevA

Manufactured

Rib Assembly (Inboard)

Warehouse Location	Loc Oty	Loc Code	
Main Warehouse			
ST	3		
51339	3		
			•

53247

	-								
W/O:		148 A Topy day	WO	RK ORDER CHANGE	ES				
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-									
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
	Res	solution:	Disposition	:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	1)			
DATE	STEP	Description of NC		Corrective Action Section			cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
							•		

November 03, 2009 3:54:49 PM

Work Order ID: 53403

Parent Item:

D2221RevH

Parent Item Name: 350 Basket Base

Comments:



Start Date: 11/4/2009

**Required Date:** 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
D3832-1RevA		Manufactured	No		100	Each	4.0000	1.0000	4 0		

Mesh (Base)

Warehouse	Loc Qty	Loc Code	
<b>Location</b>			
Main Warehouse	{	B53218 X1	
ST	2		-
46306	1		
46774	1		
Main Warehouse		•	
WA	2		
51863	2		

Each

D3833-1RevA

Mesh (Base End Face)

Manufactured No

100

12.0000 2.0000

CAD 09-11-10

Warehouse	Loc Qty	Loc Code	
<b>Location</b>			
Main Warehouse			
ST	4		
51304	4		
Main Warehouse			
WA	8		
50025	2		
53214	6		<u> </u>

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W/O:			WO	RK ORDER CHANGE	S		<u></u>			
DATE	STEP	PR	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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		PAR #:	Fault Categ	jory:	NCR: Yes No DQA: Date:					
		olution:	Disposition	:	QA: N/C Closed:			Date:		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			·····	
DATE	STEP	Description of NC			ection B Sign &		cation	Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Date	Sect	ion C	Chief Eng	QC Inspector	
								•		

D2221 BASKET BASE ASSEMBLY (AS350) (MESH SHOWN LOCALLY FOR CLARITY) NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: 42.00 lbs APPROX
9) MASK ALL HOLES PRIOR TO POWDER COATING

		ı	· · · · · · · · · · · · · · · · · · ·
ITEM	QTY	P/N	DESCRIPTION
1	Х	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

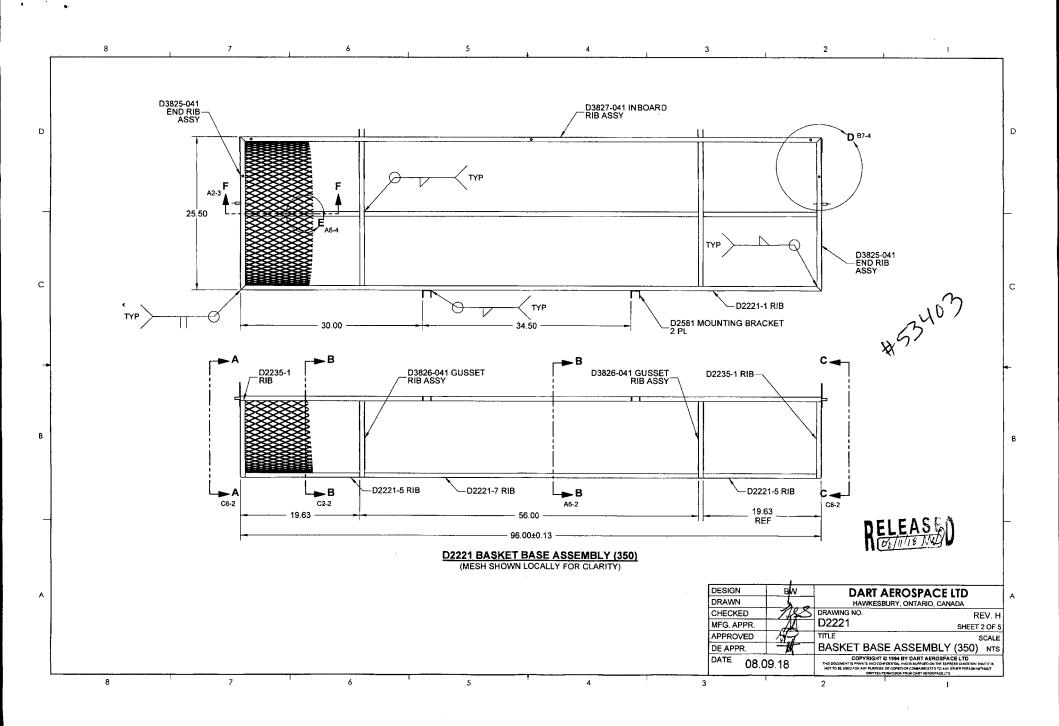
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DESIGN	BW	DART AEROSPACE LTD
DRAWN	<u>J</u>	HAWKESBURY, ONTARIO, CANADA
CHECKED	125	DRAWING NO. REV. H
MFG. APPR.	14	D2221 SHEET 1 OF 5
APPROVED	W	TITLE SCALE
DE APPR.	-	BASKET BASE ASSEMBLY (350) NTS
DATE 08.0	9.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS RIGHTED AND OSCIPPINED ON THE EXPRESS CONDITION THAT IT IS

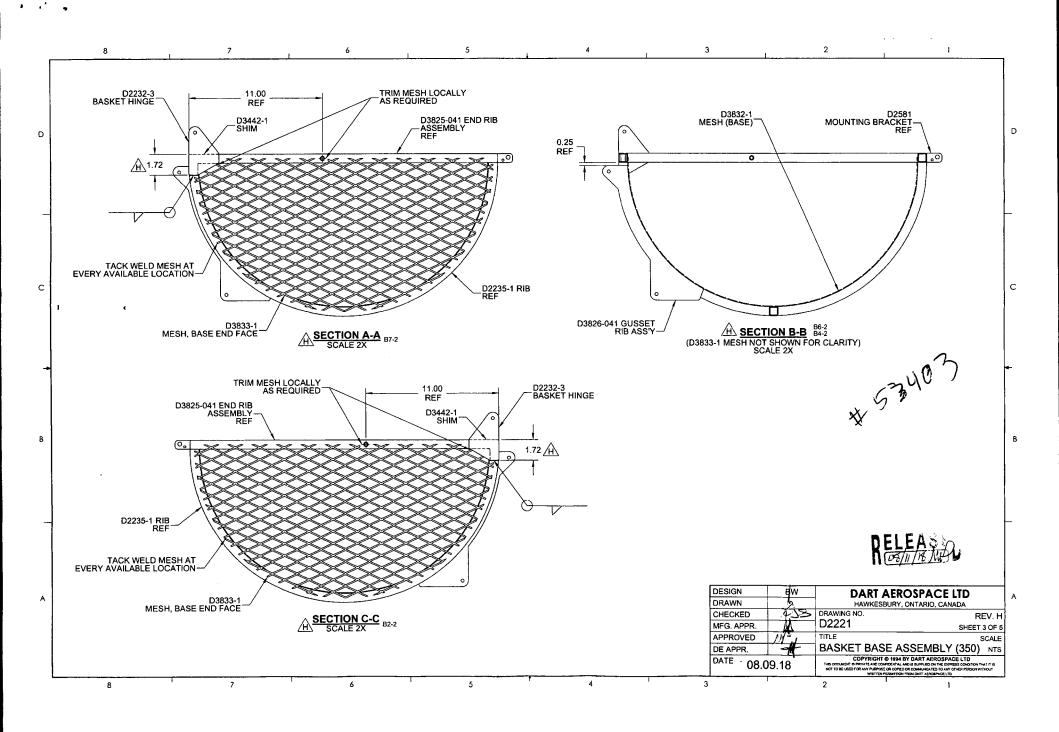
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DATE	STEP	Description of NC	Initial	Corrective Action Section	n B Sign &							Approval	Approval
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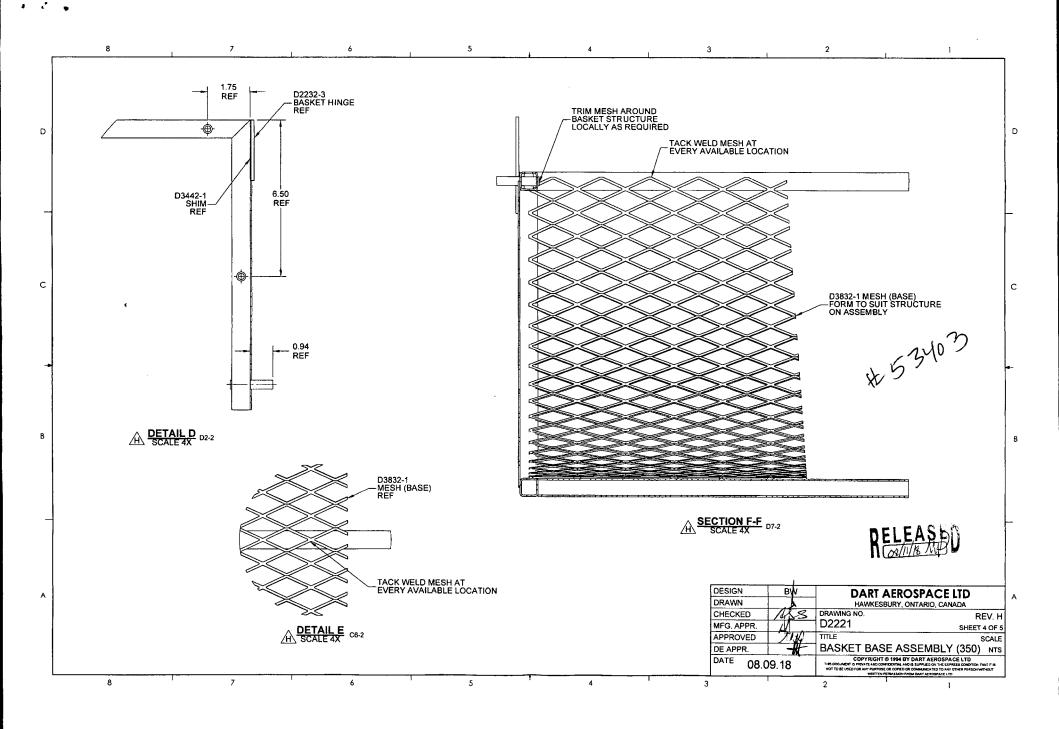


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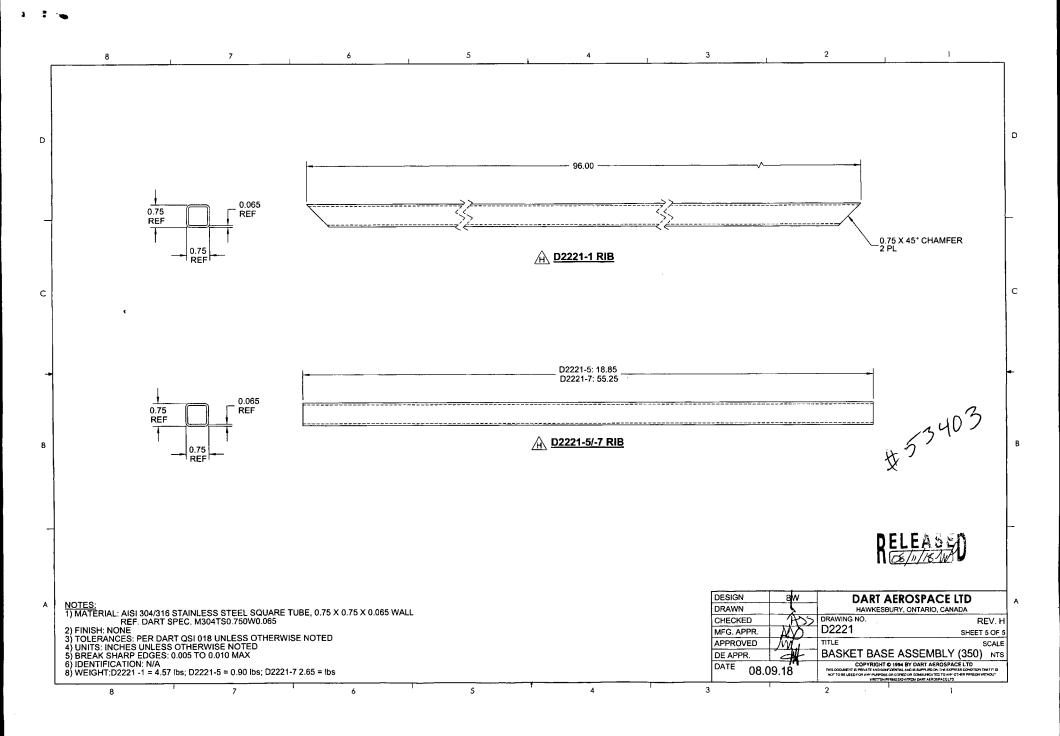
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DATE	STEP	Description of NC		Corrective Action Section B		Sign &		cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Sect	ion C	Chief Eng	QC Inspector
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NCR:		1	WORK ORD	ER NON-CONFORM	ANCE (	NCR)			APT-2000.		
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